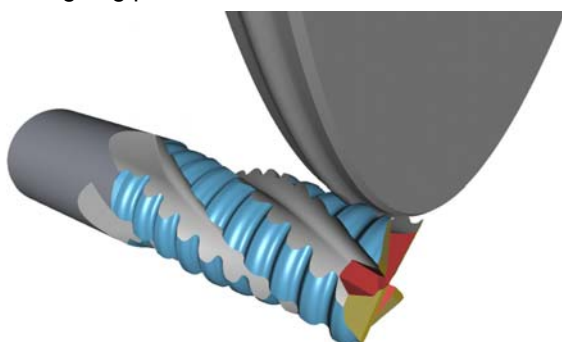


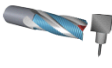
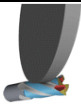



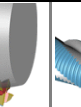
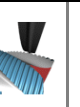







HSS Roughing Endmill Ø20 Z4

A01-800

Production of HSS Roughing Endmills with dressable CBN-formwheels can be done very effective. The dressing of the formwheel is executed each 4 to 8 endmills. The lead of the roughing profile is 4 mm.



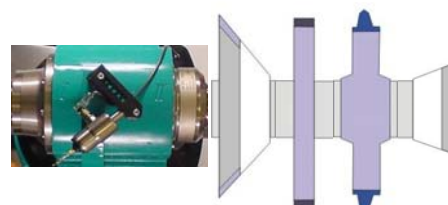
1. Cycletime for Production

Workpiece: Ø 20 mm, Z 4, Length of cutting edge 38 mm, Helix 32°, lead 4 mm Material HSS								
Operations								
Feed [mm/Min]	2000	80	100	60	80	400	100	9000
Power [kW]		12	3	3	2	2	2	1
Cutting feed [m/s]		36	32	32	32	35	50	
Used wheels								
Grinding time [s]	6	178	56	68	55	85	45	26
Total cycle time	8 Min 40							

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 B126
2	12V9 Ø125 B126
3	11V9 Ø75 B126
4	DXF Ø125 B126



2 1 4 3

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Control: Fanuc 31i

Accessories:

Responsible engineer: OP. 14.4.11

Coolant: Synthetic Oil, pressure 10 bar

Software: Quinto 5

www.schneeberger.ch

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